

Work Order ID 69655

Monday, May 16, 2011 8:55:42 AM



Page 1

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Item Name: Pilot/Co-Pilot Step, RH (Folding)

Stop



Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date:

11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

8 ulos/27

HJ GHI BG 11-5-26

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch: *M114830*

EP 11/05/26 (1)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

8 ulos/26

217

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69655

Monday, May 16, 2011 8:55:42 AM



Page 2

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Pick Kit Memo	0.00 0.00					11/5/27		
140 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		8 u/c 5/27			7		
150 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-630-032 Location: 31 PPP Rev: 31	0.00 0.00					11/5/27		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 8:55:49 AM

Page 1

Work Order ID: 69655

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)






Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
 10.05.28 added route seq DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			130	Each	26.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		26							
				117442		26							
AN310-5  NUT		Purchased	No			130	Each	30.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		30							
				114830		30							
AN3C5A  Bolt		Purchased	No			130	Each	1,324.000	3				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP-A		7							
				115835		7							
				ST350		1317							
				115422		49							
				116419		368							
				116549		100							
				117343		500							
				117508		300							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 69655

Parent Item: D412-630-032


Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011


Required Date: 5/27/2011

Start Qty: 1.00


Required Qty: 1.00

AN44-C12 Purchased No 130 Each 28.0000 1 1

 eyebolt


Location	Loc Qty	Loc Code
ST362	28	
114669	8	
117616	20	

AN4C15 Purchased No 130 Each 2.0000 1 1

 BOLT


Location	Loc Qty	Loc Code
ST358	2	
114669	2	

AN5C11 Purchased No 130 Each 38.0000 1 -1

 BOLT

Location	Loc Qty	Loc Code
ST337	38	
113950	8	
114801	30	

AN5C15 Purchased No 130 Each 32.0000 1 1

 BOLT

Location	Loc Qty	Loc Code
ST338	32	
114669	12	
117616	20	

AN960C10 NAS1149C0363 Purchased No 130 Each 0.0000 7 7

 WASHER

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 69655



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased No

130 Each

44.0000

1

1



WASHER



SP

Location

Loc Qty

Loc Code

ST347

44

102842

44

1

D3454-1

Manufactured No

130 Each

25.0000

1

1



Bushing



SP

Location

Loc Qty

Loc Code

ST054

25

58555

25

1

D3454-3

Manufactured No

130 Each

20.0000

2

2



Bushing



SP

Location

Loc Qty

Loc Code

ST058

20

56420

20

2

D3454-5

Manufactured No

130 Each

1.0000

2

2



Bushing



B68468

SP

Location

Loc Qty

Loc Code

ST054

1

58556

1

1

D3455-1

Manufactured No

130 Each

7.0000

4

4



Spacer



B68469 11/5/26 SP

Location

Loc Qty

Loc Code

ST054

7

59469

7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69655

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3455-3

Manufactured No

130 Each

6.0000

2



Spacer

Location

Loc Qty

Loc Code

ST054

6

58559

6

D3462-042

Manufactured No

130 Each

2.0000

1



Bracket Assembly

Location

Loc Qty

Loc Code

ST198A

2

68471

2

MS21043-3

Purchased No

130 Each

732.0000

3



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

652

112314

652

MS24665-227

Purchased No

130 Each

43.0000

2



COTTER PIN

Location

Loc Qty

Loc Code

ST309

43

113845

43

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69655

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-302

Purchased No

110 Each

209.0000

1

1



Cotter Pin

Location

Loc Qty

Loc Code

ST309

9

113644

9

ST357

200

117460

200

NAS1515H5

Purchased No

130 Each

128.0000

1

1



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

88

109430

88

D3455-1

Manufactured No

110 Each

7.0000

2

2



Spacer

Location

Loc Qty

Loc Code

ST054

7

59469

7

D3443-041

Manufactured No

110 Each

5.0000

1

1



Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

5

56061

3

68465

2

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 69655

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3463-042

Manufactured No

110 Each 0.0000

1 1



Step Weldment Assembly

D3443-9

Manufactured No

110 Each 0.0000

2 2



Pin

AN4GT4

Purchased No

110 Each 44.0000

1 1



BOLT

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

19

114669

19

Purchased No

130 - Each 133.0000

2 2

MS24665-229



COTTER PIN

Location

Loc Qty

Loc Code

ST309

133

111041

133

Purchased No

110 Each 43.0000

1 1

MS24665-227



COTTER PIN

Location

Loc Qty

Loc Code

ST309

43

113845

43

Monday, May 16, 2011 8:55:51 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 8:55:51 AM

Page 7

Work Order ID: 69655

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00



SS Bolt

Purchased No

110 Each

31.0000

2



2

EP 5/11/05/25

Location

Loc Qty

Loc Code

ST355

11

114801

11

ST357

20

117616

20

D3465-1



Washer

Manufactured No

110 Each

23.0000

1



1

EP 5/11/05/25

Location

Loc Qty

Loc Code

ST054

23

46134

23

AN310-4



NUT

Purchased No

110 Each

26.0000

2



2

EP 5/11/05/25

Location

Loc Qty

Loc Code

ST324

26

117442

26

D3443-043



Strut Weldment Assembly

Manufactured No

110 Each

0.0000

1



1

EP 5/4/05/25

D3454-7



Bushing

Manufactured No

110 Each

12.0000

2



2

EP 5/11/05/25

Location

Loc Qty

Loc Code

ST054

12

59256

12

2

Monday, May 16, 2011 8:55:51 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 8:55:51 AM

Page 8

Work Order ID: 69655



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 5/16/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN310-7

Purchased

No

110

Each

46.0000

1

1



NUT



Handwritten signature and date: 5/11/05/25

Location

Loc Qty

Loc Code

ST324

46

114784

46

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

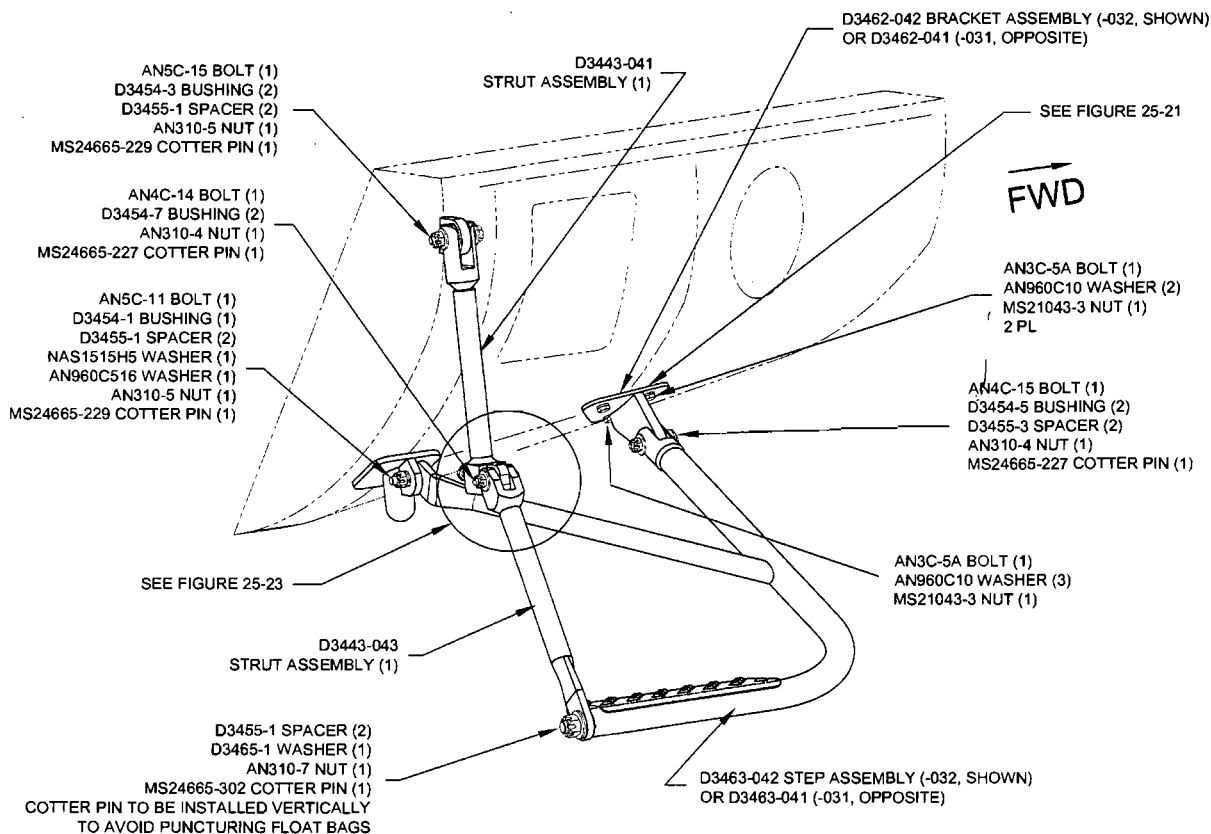


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

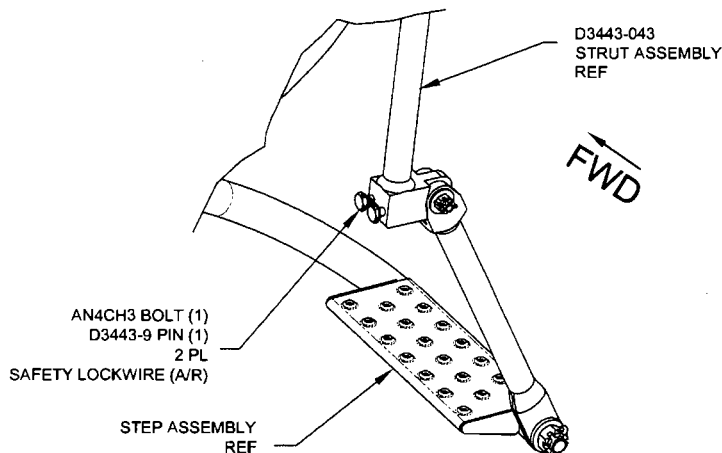
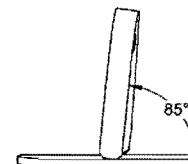
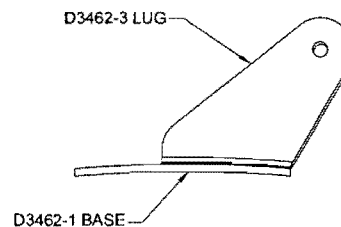
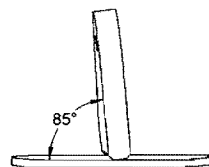
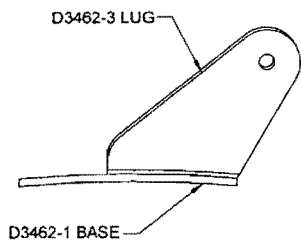
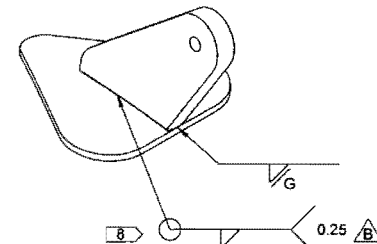
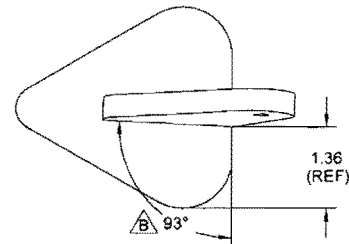
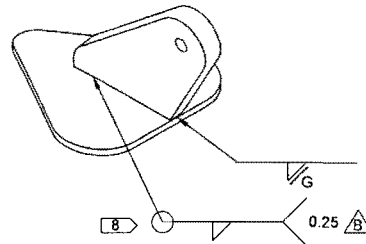
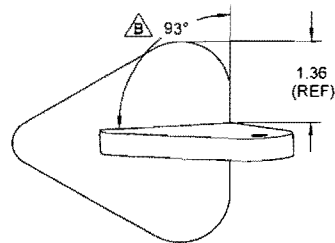


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
4 6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

REFERENCE ONLY

C	SHOW VIEWS OF D3462-041 & D3462-042. UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 TITLE BRACKET ASSEMBLY SCALE 1:2 REV. C SHEET 1 OF 2 COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

